

# Work Order ID 63463

November 2, 2010 12:56:26 PM



Page 1

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 11/02/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 10/11/02 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2445/D350-588

Rev D/D

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

Subidy

pto →  
H for CL 11/01/10

110



Purchasing

Purchasing

PURCHASING

0.00

Memo

0.00

Issue P/O: 12854  
Description: D2445 Baggage Door  
Supplier: Delastek  
Ship to Delastek (1) D0588-041 label  
Certification of Conformity and process sheet from Delastek is required.

CL 10/11/03 ①

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-588-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: / Date: 11.01.20  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>63463</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/01/11	155	incorrect qty's for - A9603D 8 should be x16 per Kit not 8 - m321042608 should be x10	11.01.12 Q81042	- update w/o + Bom add copy of new Bom as reference.	11.01.12	11.01.12	Q81042	u1a/14
		per kit no 8. R.L. w/o + Bom not correctly updated to 17n.	11.01.12 Q81042	Intuitive error Bom is correct Consona case open Working on it	11.01.13 CASE # 854072 now closed See attached printout	11.01.12	Q81042	

NOTE: Date & initial all entries

**Work Order ID 63463**

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Item ID: D350-588-041

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Start Date: 11/02/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Receive & Insp for Damage & Mat'l Certs	0.00							
	Packaging	0.00							
Packaging	Memo Ensure Certificate of Conformity & Process Sheet are attached								
130	QC6- Inspect dimensions to drawing	0.00							
	QC	0.00							
Quality Control	Memo Inspect as per Dwg D2445. Audit process sheet.								
140	Small Fab	0.00							
	Small Fab	0.00							
Small Fab	Memo Assemble all of the above parts as per Dwg D350-588								

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 63463**

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Revision ID:

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Start Date: 11/02/10 Start Qty: 1.00

Required Date: 11/19/10 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

Suboko

QC

Memo

0.00

40

Quality Control

155

Pick Kit

0.00

Packaging

Memo

0.00

4110

SPD

Packaging

160

QC4- 100% Inspect kits for completeness

0.00

Suboko

QC

Memo

0.00

Quality Control

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 63463**

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Revision ID:

Stop



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Start Date: 11/02/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	Identify as per dwg & Stock Location: <u>43</u>	0.00							
Packaging	Memo <u>REV-D</u>	0.00							
Packaging									
180 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/14/12 (1)

11/01/12 MS  
11-01-12

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries











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**Parent Item Name:** Aft Door Assembly

**Required Date:** 11/19/10

**Required Qty: 1.00**

IPP Rev:Q as  
IPP Rev:R add pick kit DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2445P 		Purchased	No			110	Each	0.0000	1	1			
<div style="display: flex; justify-content: space-between; align-items: center;"> <span>B 63483</span>  <span>RT 10-12-20</span> </div>													
AFT DOOR ASSEMBLY AN526C832R9 		Purchased	No			140	Each	149.0000	8	8			
<div style="display: flex; justify-content: space-between; align-items: center;"> <span>M 116400 x 8</span>  <span>RT 10-12-20</span> </div>													
<div style="display: flex; justify-content: space-between;"> <div> <p><u>Location</u></p> <p>ST327</p> <p>115422</p> <p>115835</p> <p>115936</p> </div> <div> <p><u>Loc Qty</u></p> <p>149</p> <p>3</p> <p>46</p> <p>100</p> </div> <div> <p><u>Loc Code</u></p> <p>_____</p> <p>_____</p> <p>_____</p> <p>_____</p> </div> </div>													
AN960JD10 	NAS1149D0363J	Purchased	No			140	Each	8.0000	2	2			
<div style="display: flex; justify-content: space-between; align-items: center;"> <span>M 115622</span>  <span>RT 10-12-20</span> </div>													
<div style="display: flex; justify-content: space-between;"> <div> <p><u>Location</u></p> <p>ST</p> <p>107715</p> <p>ST335</p> <p>105792</p> </div> <div> <p><u>Loc Qty</u></p> <p>6</p> <p>6</p> <p>2</p> <p>2</p> </div> <div> <p><u>Loc Code</u></p> <p>_____</p> <p>_____</p> <p>_____</p> <p>_____</p> </div> </div>													
AN960JD8 	NAS1149DN832J	Purchased	No			140	Each	10.0000	8	8			
<div style="display: flex; justify-content: space-between; align-items: center;"> <span>M 116392</span>  <span>RT 10-12-20</span> </div>													
<div style="display: flex; justify-content: space-between;"> <div> <p><u>Location</u></p> <p>ST347</p> <p>105059</p> </div> <div> <p><u>Loc Qty</u></p> <p>10</p> <p>10</p> </div> <div> <p><u>Loc Code</u></p> <p>_____</p> </div> </div>													

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

November 2, 2010 12:56:26 PM

Work Order ID: 63463

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2143 Manufactured No  
Hinge Bracket

140 Each 10.0000  
*363595*

1 1



*ET 10-12-20*

Location Loc Qty Loc Code

ST198 10  
55323 10

D2144 Manufactured No  
Hinge Bracket

140 Each 35.0000

1 1



*ET 10-12-20*

Location Loc Qty Loc Code

ST198 35  
55179 35

D2463 Manufactured No  
Seal

140 f 486.1100

7.25 7.25



*ET 11-01-10*

Location Loc Qty Loc Code

ST404 486.11  
55561 1.68  
62597 484.43

*ET 7.25*

(D2463-0870) cut (1) at 87.00"  
\*\*\*\* per kit\*\*\*\*

D2585 Manufactured No  
Mounting Channel

140 Each 50.0000

2 2



*ET 10-12-20*

Location Loc Qty Loc Code

ST018 33  
62676 33  
ST019 17  
59873 17

*ET 2*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2586 Manufactured No



Door Latch

140 Each 52.0000 2 2  
*364676 x2* *RT 11-01-10*

Location Loc Qty Loc Code

ST204 52  
 61655 52

D2621 Manufactured No



Latch Plate, 350 Spacepod

140 Each 67.0000 2 2

*RT 10-12-20*

Location Loc Qty Loc Code

ST021 67  
 46842 7  
56526 60

*x2*

D2857-1 Manufactured No



Hinge Bracket

140 Each 28.0000 1 1

*RT 10-12-20*

Location Loc Qty Loc Code

ST026 28  
 56529 5  
57924 23

*x1*

D2857-2 Manufactured No



Hinge Bracket

140 Each 32.0000 1 1

*RT 10-12-20*

Location Loc Qty Loc Code

ST027 32  
 55020 1  
 56530 7  
57925 24

*x1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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November 2, 2010 12:56:26 PM

Work Order ID: 63463

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

140

Each

160.0000

8

8



Nut

M 116188



BT 10-12-20

Location

Loc Qty

Loc Code

ST300

160

115835

160

MS21042L3

Purchased

No

140

Each

1,898.000

4

2



Nut



BT 10-12-20

Location

Loc Qty

Loc Code

ST300

1898

114784

898

115835

1000

K2

MS27039-1-15

Purchased

No

140

Each

47.0000

2

2



Screw



116169 K2

BT 10-12-20

Location

Loc Qty

Loc Code

ST292

47

114056

2

114718

45

ANS26C1032R7

Purchased

No

155

Each

46.0000

2

2



Screw



M116304 11/11/10

Location

Loc Qty

Loc Code

ST328

46

113064

1

113749

1

114056

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 63463

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

AN526C832R8

Purchased

No

155

Each

132.0000

8

8



Screw



M116410 11/11/10

Location

Loc Qty

Loc Code

ST327

132

114615

32

114718

100

AN960JD10

NAS1149D0363J

Purchased

No

155

Each

8.0000

2

12



Washer



M115622 11/11/10

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960JD8

NAS1149DN832J

Purchased

No

155

Each

10.0000

16

16



Washer



M116513 11/11/10

Location

Loc Qty

Loc Code

ST347

10

105059

10

D2150

Manufactured

No

155

Each

20.0000

2

2



Packer Doubler, Hinge



B64764 11/11/10

Location

Loc Qty

Loc Code

ST007

20

55178

20

November 2, 2010 12:56:26 PM

Shop Packet Print

Page 5

pho  
1st page

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2151  
Packer Doubler, Hinge

Manufactured No

155

Each

43.0000

2 2



B6430 11/11/10

Location

Loc Qty

Loc Code

ST007

43

55319

5

62246

38

D2153  
Door Prop

Manufactured No

155

Each

16.0000

1 1



B6431 11/11/10

Location

Loc Qty

Loc Code

ST272

16

59818

16

D2154  
Stud Bracket

Manufactured No

155

Each

6.0000

1 1



B6432 11/11/10

Location

Loc Qty

Loc Code

ST007

6

55325

3

62479

3

D2237  
Striker Plate

Manufactured No

155

Each

52.0000

2 2



B64426 11/11/10

Location

Loc Qty

Loc Code

ST009

5

60492

5

ST010

47

62212

47

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2461

Manufactured No

155 f

115.7072 7.25 7.25



Neoprene "D" Seal



B63880 11/11/10

Location

Loc Qty

Loc Code

ST402

115.7072105

39782

6.5

55054

109.207211

(D2461-0870) cut (1) at 87.00"  
\*\*\*\* per kit\*\*\*

D2589

Manufactured No

155 Each

161.0000 1



Keys, Key Chain, 350 Hinge



11/11/10

Location

Loc Qty

Loc Code

ST019

161

58194

161

D2690-17

Manufactured No

155 Each

16.0000 1



Cable



B64786 11/11/10

Location

Loc Qty

Loc Code

ST021

16

62480

16

D2858-1

Manufactured No

155 Each

15.0000 1



Hinge Bracket



11/11/10

Location

Loc Qty

Loc Code

ST027

15

56423

9

61522

6

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Shop Packet Print

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Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2858-2 Manufactured No

155 Each

7.0000

1

1



Hinge Bracket



B62020 ulh/sf

Location

Loc Qty

Loc Code

ST027

7

56048

1

61523

6

FG-778150-550-ROL Purchased No

155 sf

1,840.750

1

1



7781 9oz Glass 50"x125yd



ulh/sf

Location

Loc Qty

Loc Code

ST404

1840.75

108932

18

111166

397

113905

1425.75

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4 Purchased No

155 Each

5,984.000

12

12



RIVET



ulh/sf

Location

Loc Qty

Loc Code

ST316

5984

104374

1984

110398

4000

MS20470AD4-5 Purchased No

155 Each

526.0000

18

18



Rivet, Universal Head



M116410 ulh/sf

Location

Loc Qty

Loc Code

ST309

461

114761

461

ST319

65

111916

65

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 9

November 2, 2010 12:56:26 PM

Work Order ID: 63463

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

155

Each

160.0000

10 10



Nut

Location

Loc Qty

Loc Code

ST300

160

115835

160

MS21042L3

Purchased

No

155

Each

1,898.000

4



Nut

Location

Loc Qty

Loc Code

ST300

1898

114784

898

115835

1000

MS27039-08-11

Purchased

No

155

Each

45.0000

2



Screw

Location

Loc Qty

Loc Code

ST288

45

114382

45

11/16/10 11/11/10  
Ph  
1st page  
11/10  
4  
2 2  
11/10/10  
2

November 2, 2010 12:56:26 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

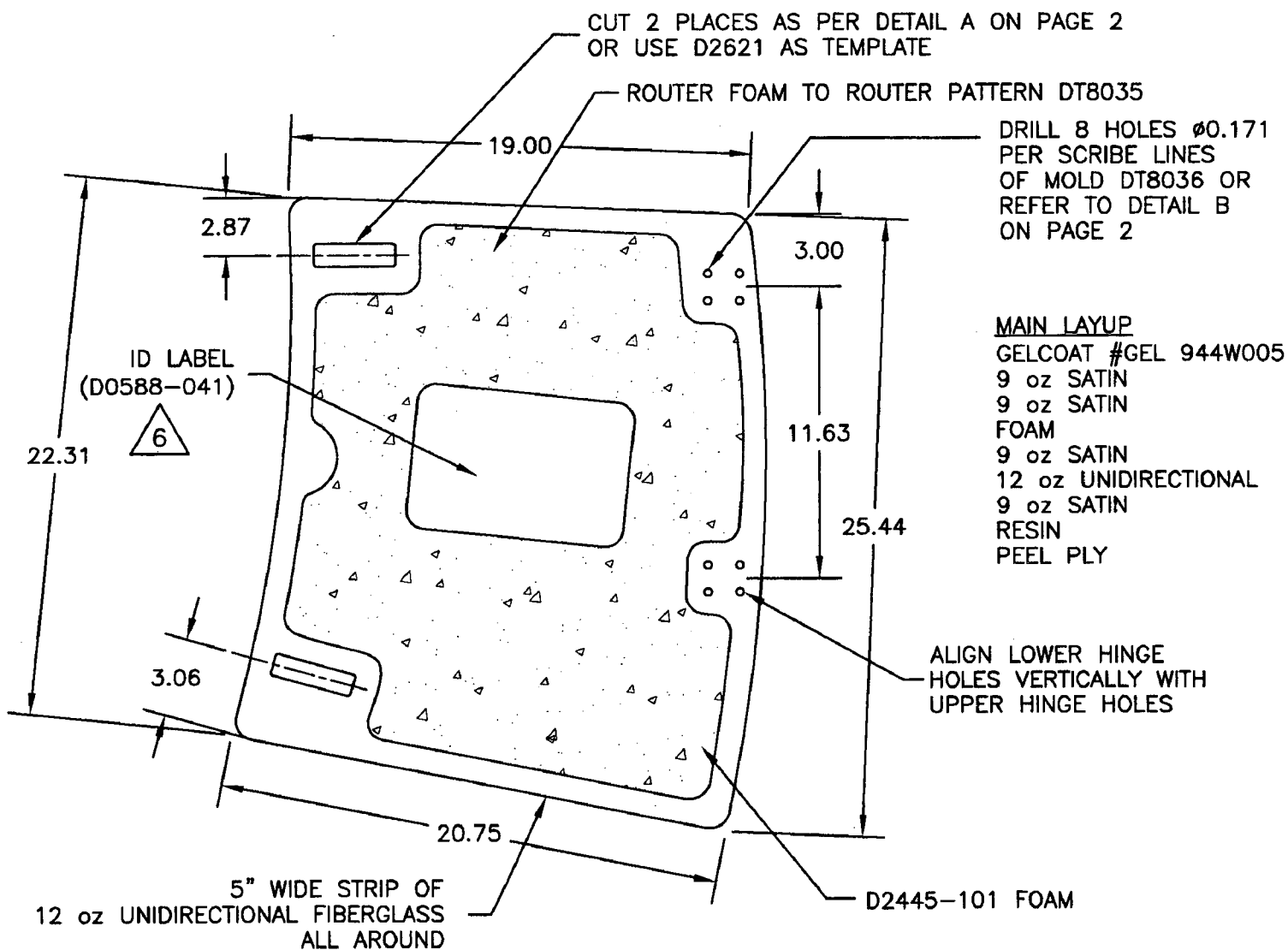
**NOTE:** Date & initial all entries



DESIGN <b>JB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2445</b>	REV. D SHEET 1 OF 2
DATE <b>06.06.09</b>	TITLE <b>AFT BAGGAGE DOOR</b>		SCALE <b>1:7</b>
<b>A</b>	<b>97.07.15</b>	<b>NEW ISSUE</b>	
<b>B</b>	<b>02.01.24</b>	<b>ADD D2621; D2445-101</b>	
<b>C</b>	<b>04.02.09</b>	<b>REMOVE D2621; UPDATE NOTES</b>	
<b>D</b>	<b>06.06.09</b>	<b>ADD DIMENSIONS TO PERIMETER</b>	

**RELEASED**

06.11.13 *[Signature]*



**NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

0210/11/02

W10:63/63

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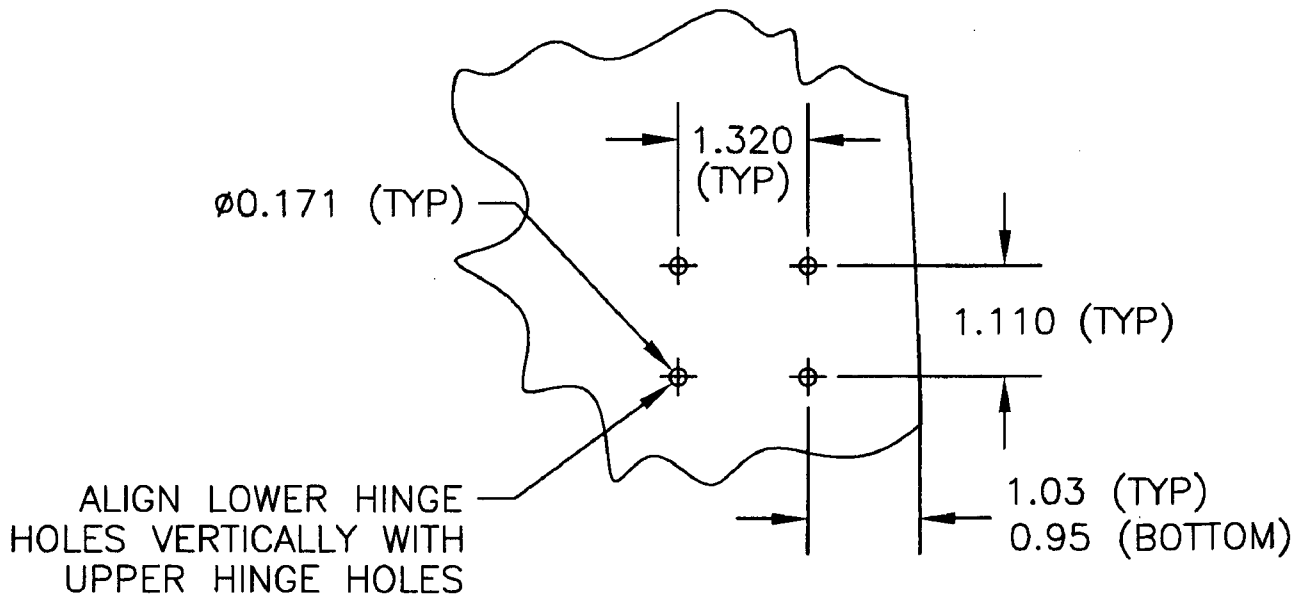
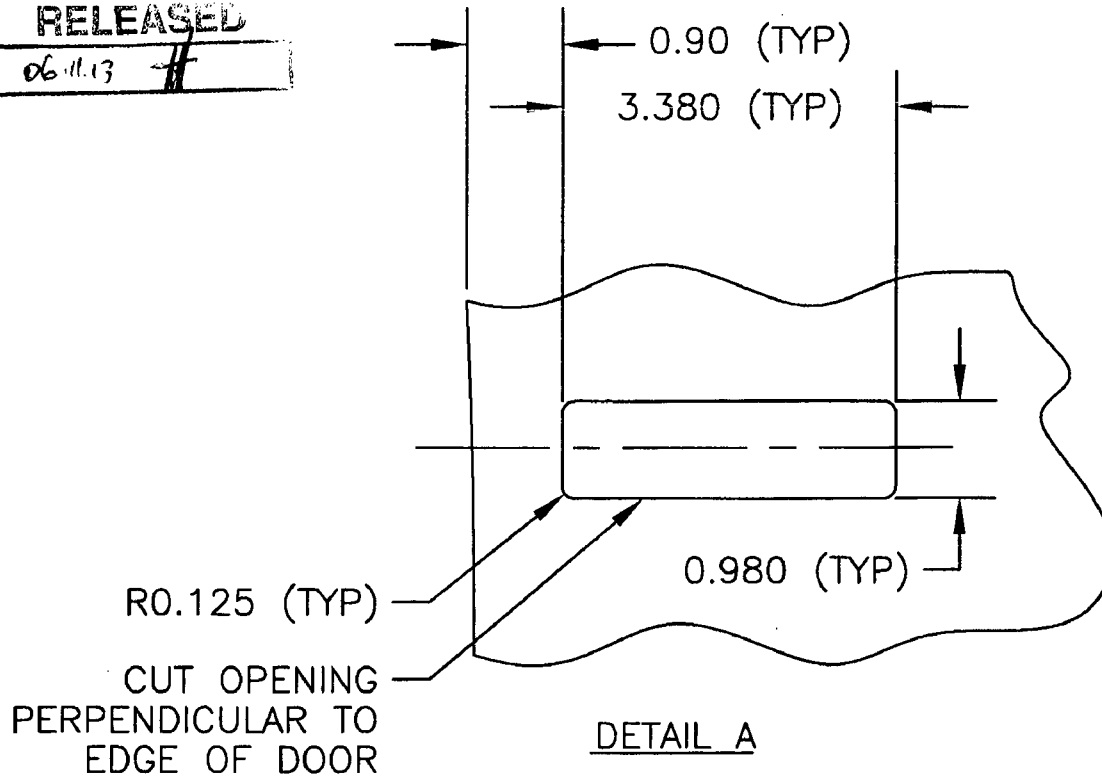
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**DART**

DESIGN <b>JB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09	TITLE AFT BAGGAGE DOOR		SCALE 1:2

RELEASED

06.11.13 *[Signature]*



DETAIL B

W1063463

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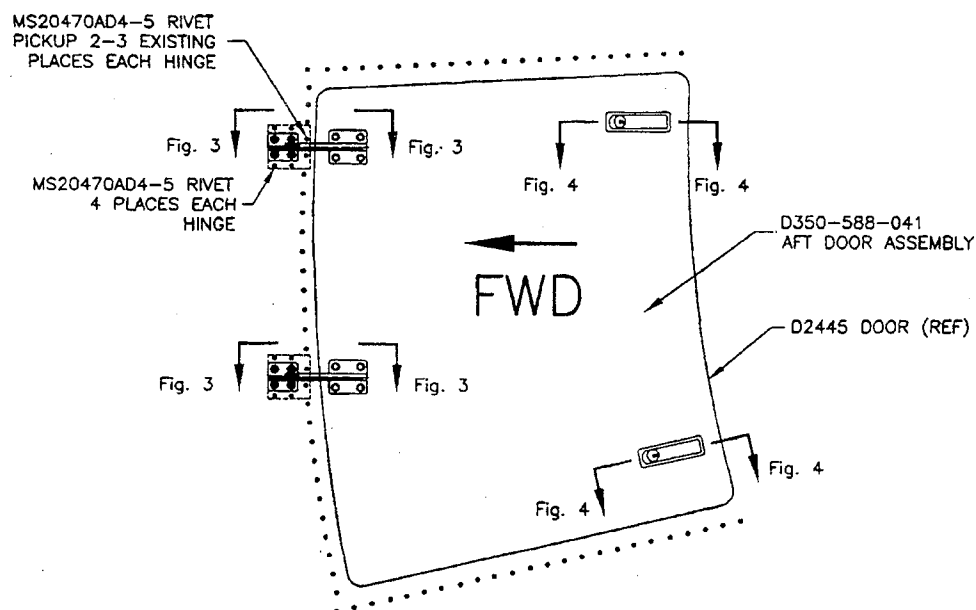


Figure 2: Baggage Door Outside View

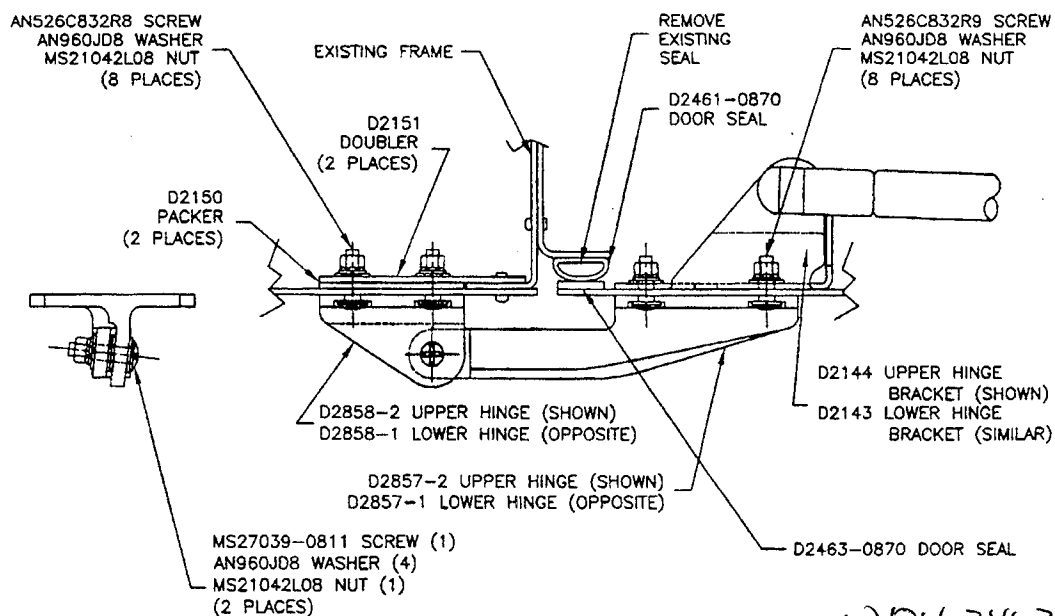


Figure 3: Hinge Detail

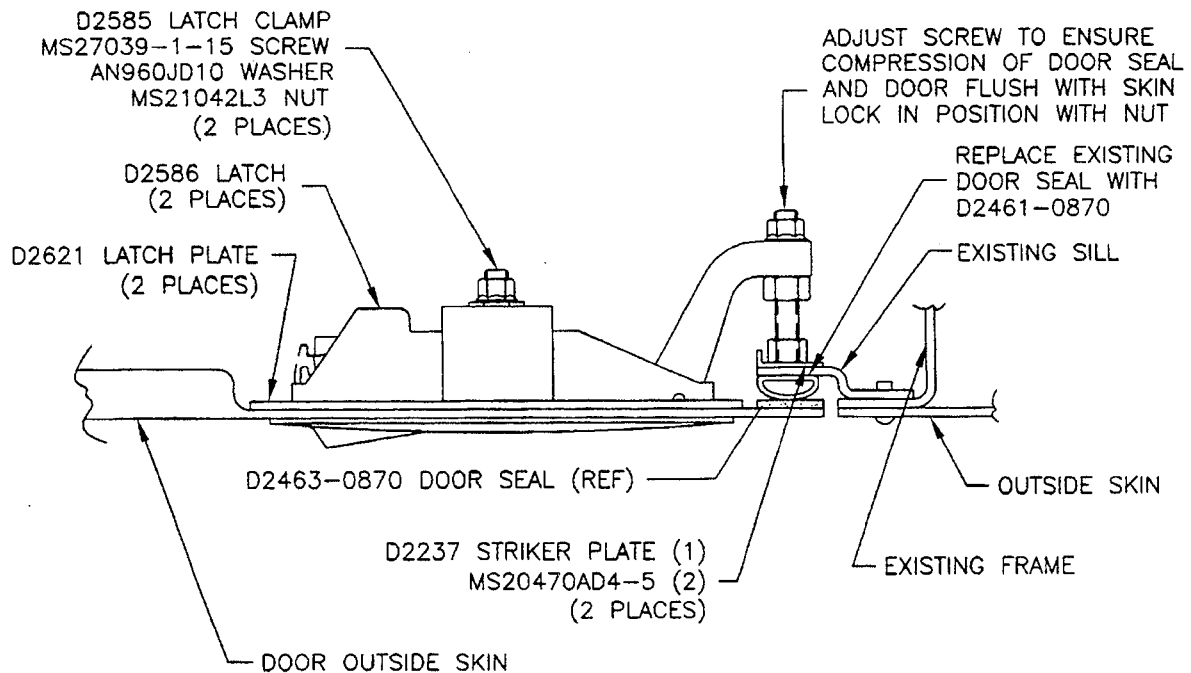


Figure 4: Latch Section

W10:63463

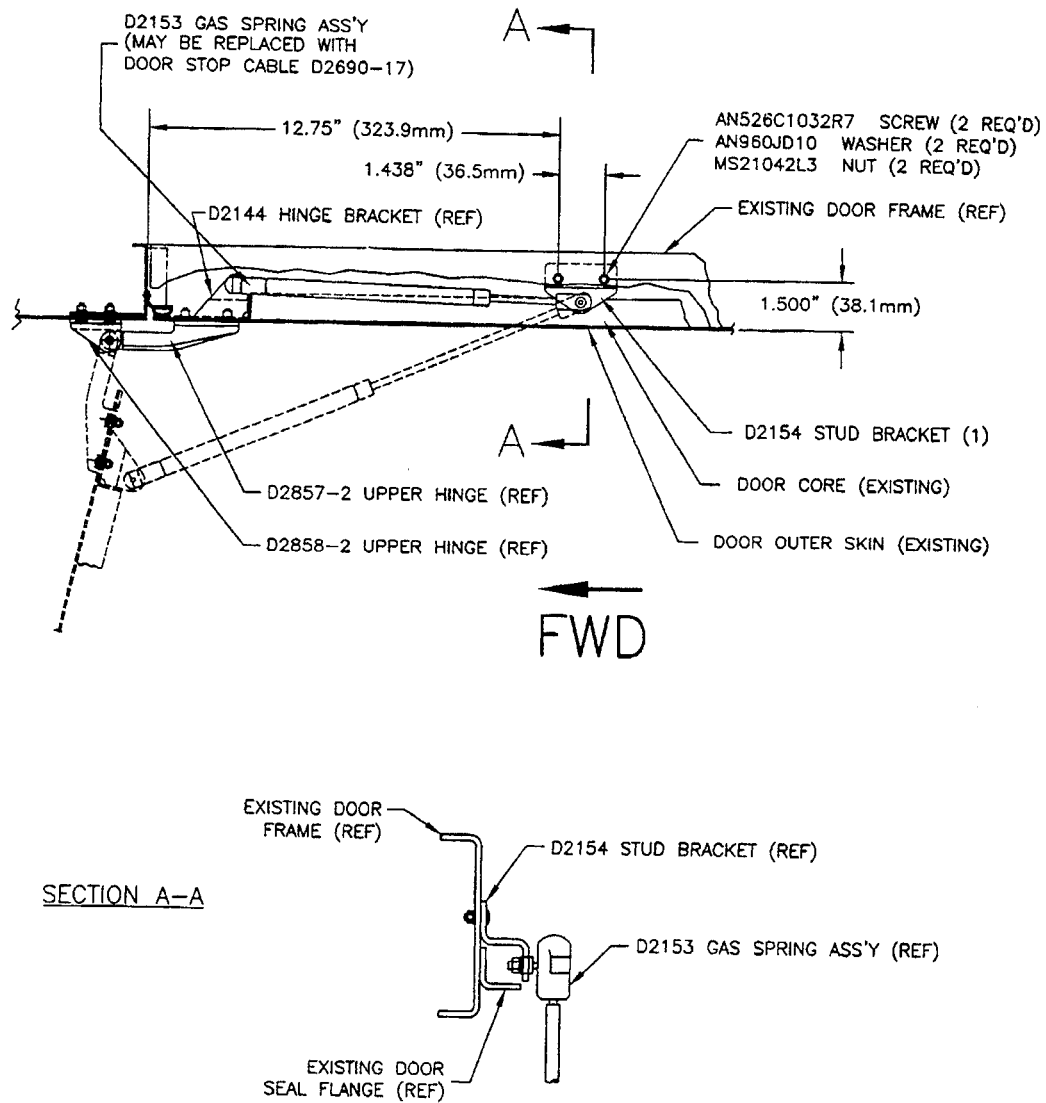


Figure 5: Gas Spring Installation

w10. b 3463

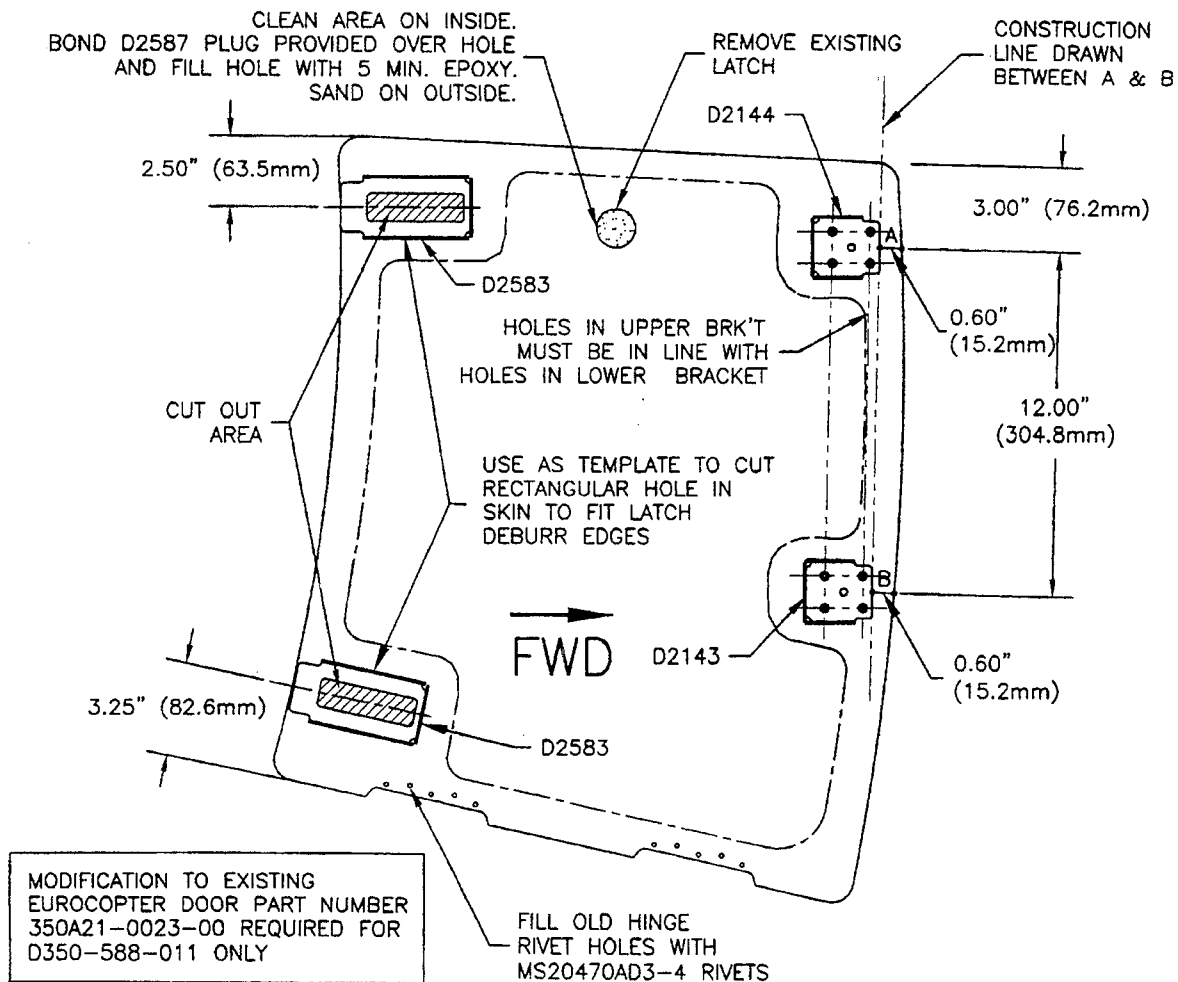


Figure 6: Baggage Door Inside View

w10: 63463



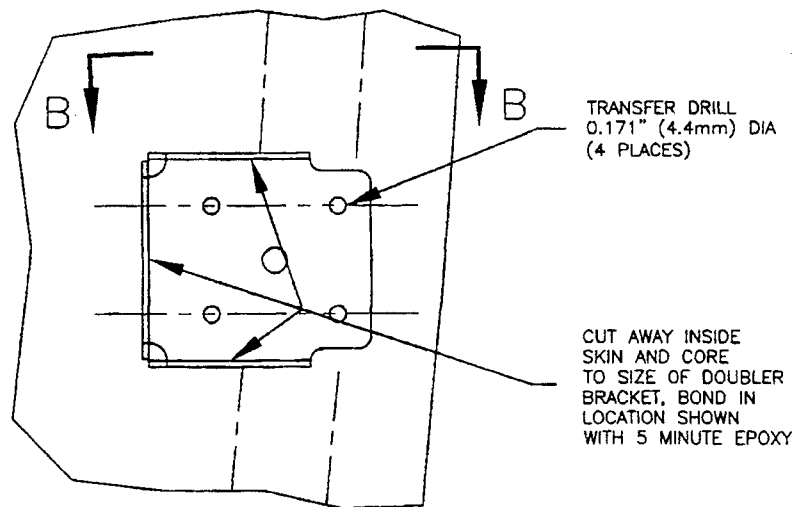
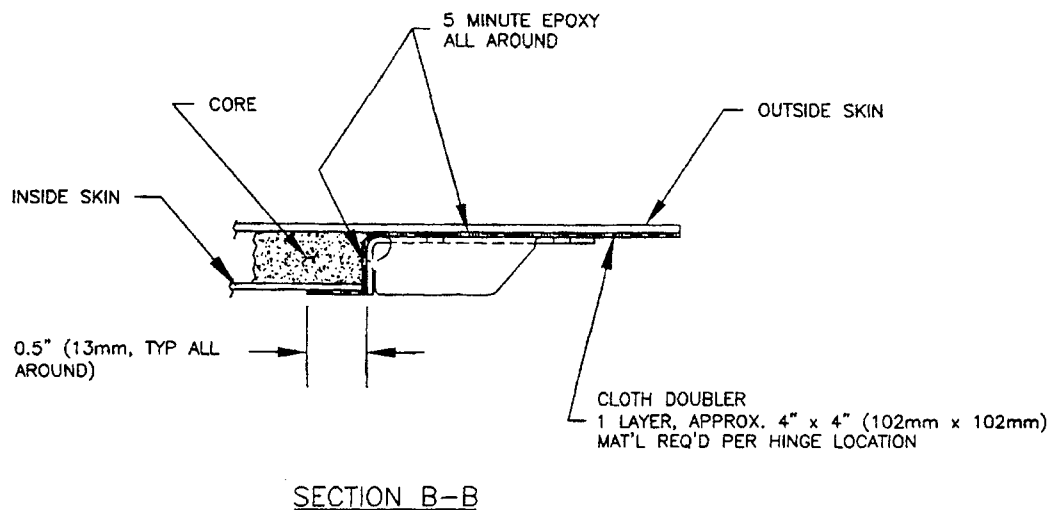


Figure 7: Typical Doubler Bracket Installation

W/D. 63463

**3.3 WEIGHT AND BALANCE**

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

\* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

**3.4 PARTS LISTS**

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

W10.463463

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Revision: D  
Date: 02.01.17



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO12854

Purchase Order Date 11/03/10

PO Print Date 11/03/10

Page Number 1 of 2

Order From :

VU-DEL003

DELASTEK INC  
2699 5E AVENUE, LOCAL C.P 123

GRAND-MERE, QC G9T 5K7  
CA

**PAID**  
*11/11/10*

Contact Name

Vendor Phone 819 533 5788

Vendor Fax 819 533 3494

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
D2445P		AFT DOOR ASSEMBLY	12/03/10 Yes	✓ 1.00 Each	Purolator ground	\$580.0000	\$580.00
		Special Inst:	AS PER DWG D 2445 REV. D B63462				
D2445P		AFT DOOR ASSEMBLY	12/03/10 Yes	✓ 1.00 Each	Purolator ground	\$580.0000	\$580.00
		Special Inst:	AS ABOVE B63463				
D2445P		AFT DOOR ASSEMBLY	12/10/10 Yes	1.00 Each	Purolator ground	\$580.0000	\$580.00
		Special Inst:	AS ABOVE B63464				
D2445P		AFT DOOR ASSEMBLY	12/10/10 Yes	1.00 Each	Purolator ground	\$580.0000	\$580.00

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Range Nbr: 1

Change Date: 11/03/10



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	36411
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Ship to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
15/12/2010	03/11/2010	15934	Chantal Lavoie	PO12854			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0013	D350-588-041 Aft Baggage Door (D2445) B63463 U de M : Each Drawing N° : D2445 Rév.: D  <u>No. série</u> B63463  <u>No. lot</u> 30101  810/12/20			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department


AQ-357



Date: Jeudi, 2010-11-04 12:54:39  
 Utilisateur: Pascal Carignan

## Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: N° D2445, AFT BAGGAGE DOOR
Numéro Job	: 30101	Numéro Article	: DKC134-0013
Numéro Soumission	: 3959	Numéro Dessin	: D2445
Numéro B.A.	:	Projet Numéro	: DKC134
Cette fois	: 2010-11-04 No. B.V. :	Révision dessin	: D
Prsht Rev.	: NC	Matériel	: Composite
Prem. fois	: - - Type :	Date Dûe	: 2010-11-10 Qté: 1 Udm: UNITE
Job précédente	: 30100		

Écrit par :  \_\_\_\_\_  
 Vérifié & Approuvé par : \_\_\_\_\_  
 Commentaires : N° de pièce Client: D2445

B63463

 Process Sheet Rév.: 00 Création du premier dans DKA à partir de la  
 Rév.: 10 de DKC

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0085	FREKOTE 3,78L 44-NC
-----	--------	---------------------

Commentaire Qty.: 0.20 UNITE(s)/Unit Total : 0.20 UNITE(s)

2.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DT-8036 selon IG 0009

Date: \_\_\_\_\_ Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_

3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Commentaire Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

 Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-28605-1

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Commentaire Qty.: 0.0320 GALLON(s)/Unit Total : 0.0320 GALLON(s)

 Catalyst N° DDM-9 N° de Lot: 1-22176-1

5.0	AC0747	Acetone
-----	--------	---------

Commentaire Qty.: 0.130 KILOGRAMME(s)/Unit Total : 0.130 KILOGRAMME(s)

6.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du matériel :

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

 Date: 11-11-10 Sceau:  Temps Début: \_\_\_\_\_ Temps Fin: \_\_\_\_\_

Date: Jeudi, 2010-11-04 12:54:39

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 30101

Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

7.0 GEL COAT Application du Gel Coat



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'application du Gelcoat selon IG 0019

Date: 11-11-10 Sceau: Temps Début: \_\_\_\_\_ Temps Fin: \_\_\_\_\_

8.0 AC0883 Tissu à délaminer Release ply B

Commentaire Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)

9.0 AC0884 Wrightlon 5200 Bleu P3

Commentaire Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)

10.0 AC0885 Feutre de drainage N° Airweave N 10

Commentaire Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)

11.0 AC0943 Stretchlon 200 poche à vide Vert

Commentaire Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)

12.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentaire Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-26697-1

13.0 AMB0349 Fiberglass 12 oz Unidirectional

Commentaire Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-22549-1

14.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Commentaire Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)

15.0 PREP-GENERAL Préparation du matériel



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage













2 fois le tissu à délaminer ( non nécessaire lors du bagging du core ).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: Jeudi, 2010-11-04 12:54:39  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 30101		Numéro Article: DKC134-0013	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
21.0	AMB0286	Catalyst N° DDM-9	
Commentair Qty.: 0.0042 GALLON(s)/Unit Total : 0.0042 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-22176-1</u>			
22.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Commentair Qty.: 0.120 KILOGRAMME(s)/Unit Total : 0.120 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-28751-1</u>			
23.0	PREP-GENERAL	Préparation du matériel	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire la préapration de la résine selon les quantités requise, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core.			
Laisser sécher pendant 1 heure.			
Date: <u>5-11-10</u> Heure Début: _____ Heure Fin: _____ Sceau: 			
24.0	AAC1611	Polybond B46F	
Commentair Qty.: 0.045 KIT(s)/Unit Total : 0.045 KIT(s) Polybond B46F N° de Lot: <u>1-26580-1</u>			
25.0	DKC134-0029	Foam Core N° D2445-101 ( Pour AFT Baggage Door )	
Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Foam Core N° D2445-101 ( Pour AFT Baggage Door ) N° de Job: <u>26405</u>			
26.0	ASSEMBLAGE	Assemblage mécanique	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Assembler le DKC134-0029 selon IG 0033			
Date: <u>15-11-10</u> Heure Début: _____ Heure Fin: _____ Sceau:  			
27.0	BAGGING	Faire le bagging sur la pièce	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire la poche à vide selon IG 0012			
Laisser sécher à l'air embiant pendant 2 heures minimum.			
Date: <u>15-11-10</u> Heure Début: _____ Heure Fin: _____ Sceau:  			
Curing Début: <u>11:15</u> Curing Fin: <u>2:15</u>			

Date: Jeudi, 2010-11-04 12:54:39  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 30101

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

28.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.1360 GALLON(s)/Unit Total : 0.1360 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-22176-1

29.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-28751-1

30.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 16-11-10 Heure Début: — Heure Fin: — Sceau:

31.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 16-11-10 Heure Début: — Heure Fin: — Sceau:

32.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher à l'air ambiant pendant 4 heures minimum.

Date: 16-11-10 Heure Début: — Heure Fin: — Sceau:

Curing Début: 10:25 Curing Fin: 8:00



Date: Jeudi, 2010-11-04 12:54:39  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 30101

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

33.0 DÉMOULAGE Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Démouler la pièce selon IG 0018

Date: 17-11-10 Heure Début: — Heure Fin: — Sceau:



34.0 TRIMAGE Trimage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2445.

Date: 17-11-10 Heure Début: — Heure Fin: — Sceau:



35.0 AAC1605 Label N° D0588-041

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)  
Label N° D0588-041 N° de Lot: 1-28915-1

36.0 AAC1609 Surface Veil

Commentair Qty.: 0.07 VERGE(s)/Unit Total: 0.07 VERGE(s)  
Surface Veil N° de Lot: —

37.0 AAC1220 Résine Mia-Poxy 100

Commentair Qty.: 0.007 GALLON(s)/Unit Total: 0.007 GALLON(s)  
Résine Mia-Poxy 100 N° de Lot: 1-25679-1

38.0 AAC1221 Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.007 QUART(s)/Unit Total: 0.007 QUART(s)  
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: 1-25679-2

39.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Coller le abel N° D0588-041 selon IG 0111.

Laisser scher pendant 4 heures.

Date: 23/11/10 Heure Début: — Heure Fin: — Sceau:



Date: Jeudi, 2010-11-04 12:54:39  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 30101

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Quantité: 1 Date: 01-Dec 10 Sceau: L.B.

## 52.3 WEIGHT AND BALANCE

REFERENCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

\* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

## 52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER - 8
4	4	AN960JD10	WASHER - 2
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08) - 8
4	4	MS21042L3	NUT (or MS21042-3) - 2
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

## REFERENCE

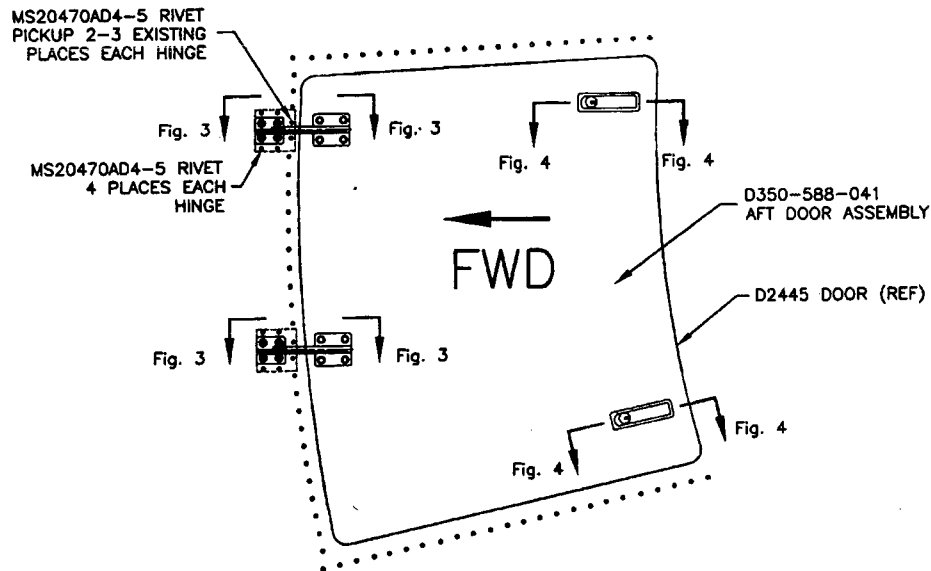


Figure 2: Baggage Door Outside View

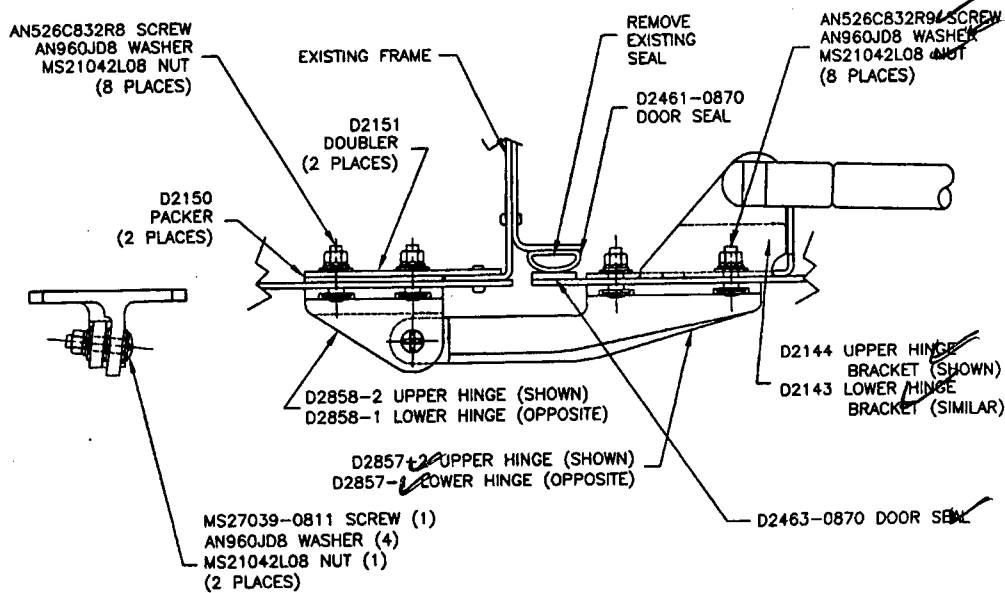


Figure 3: Hinge Detail

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Revision: D

Date: 02.01.17

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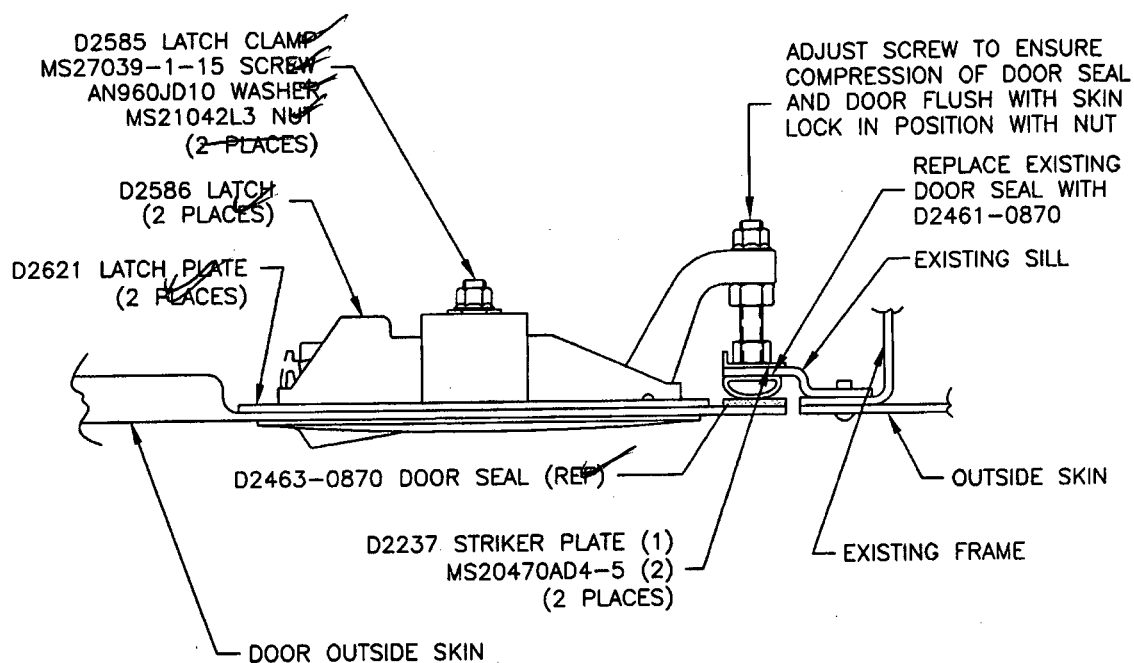


Figure 4: Latch Section

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Revision: D

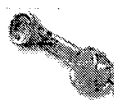
Date: 02.01.17

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Case Details	
Case:	854072
Screen Id:	Bill Of Materials
Condition:	Closed
Status:	Closed
Date Created:	12/21/2010 11:33:21 AM
Company Name:	Dart Aerospace Ltd
Contact:	Linda Lacelle
CRs Attached:	

Issue:	
	when same components in bom, do not show up w/ correct qty on pick sheet

Case History:	
12/21/2010 11:33:22 AM	<b>Logged by websupport websupport</b> *** Performed by contact: Linda Lacelle, (613) 632-9577 Contact me via: Email Search Knowledgebase: Yes Version: IMS Loc/Lot Problem Description: it seems that when the same item is issued for a different route sequence on a BOM, they do not come out properly on the picklist sheet
12/21/2010 11:33:46 AM	<b>Logged by websupport websupport</b>  Added attachment {be7d10be-c298-414a-9003-60eafba6e06a} _CCF21122010_00000.jpg with description Click on link to view attachment: <a href="#">Attachment</a>
12/21/2010 2:40:51 PM	<b>Logged by Zeljko Djuric</b> To: llacelle@dartaero.com Re: Case 854072: when same components in bom, do not show up w/ correct qty on pick sheet  Hi Linda,  I am not sure if I am following your concern since it looks to me 2 different parts are circled in your Picklist Print report. If your concern is item MS21042L08 that one has 8 units in inventory and 8 and 10 Quantity Per Assembly respectively declared in the BOM of parent item D350-588-041.  So, please if there is still some confusion please clarify it.
12/21/2010 3:17:36 PM	<b>Logged by websupport websupport</b> the first column is Qty on hand, the second column is Qty per kit, the third column is Total Qty (we had this mod put in to show qty per kit, ans/total qty awhile back), so the qty per kit and the total qty should be the same if the v/o is for 1. The MS21042L08 shows qty per kit 8, total qty 10, and the MS21042L3 show a qty per kit 4, total qty 2, doesn't make sense. I can only find this happening in BOMs that have the same item ID twice in the BOM.
12/21/2010 5:23:23 PM	<b>Logged by Zeljko Djuric</b> To: llacelle@dartaero.com Re: Case 854072: when same components in bom, do not show up w/ correct qty on pick sheet  Linda,  Since this is a customized form I am dispatching to our Customization dept.
12/21/2010 5:27:24 PM	<b>Logged by Zeljko Djuric</b>
12/22/2010 3:16:10 PM	<b>Logged by Rodney Hall</b> Found the issue. The Qty to pick was not using the Route Sequence ID when looking up the quantity. So it was always getting the first value, which isn't correct when an item appears in more than one route step. Updated the report and updated the installer. Sent Linda updated Installer.
1/13/2011 1:56:55 PM	<b>Logged by websupport websupport</b> The updater installer worked! thx



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